

Work Order ID 85242

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85242

Page 1

Item ID: D412-742-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 05/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-742

E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG007

JB

Siribator

12/7/4

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

1

12/07/03 JB

SP

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Siribator

12

Picklist Print

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Work Order ID: 85242

85242

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev: C
 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP Rev: F: add
 AN4C7A DD 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per
 DSI9517 REV.B DD verified by: EC IPP rev: H 12.01.12 PER IIN
 REV.E DD VERF: IPP Rev: I add AN4C7A DD 12.03.14
 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A		Purchased	No			110	Each	48.0000	4	4			

AN4C47A
 Bolt

**

JB SP

Location	Loc Qty	Loc Code
ST361	48	
118451	6	
119798	2	
121009	22	
121585	18	

D412-742-043

Manufactured No

110

Each

0.0000

1

1

**

121585
 B85251 SP

D412-742-043

Replacement Float Skidtube

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Offset/Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unauthorized <input type="checkbox"/>																											

FAULT CATEGORY							
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other				

Picklist Print

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2571

Manufactured No

110 Each

18.0000

1

1

D2571

Saddle, Fwd Out 205

**

Location

Loc Qty

Loc Code

ST

1

11644

1

ST425

-13

ST432

17

83451

5

83670

12

ST433

13

83670

D2572

Manufactured No

110 Each

2.0000

1

1

D2572

Saddle, Fwd In 205

**

Location

Loc Qty

Loc Code

ST432

2

71107

2

D2573

Manufactured No

110 Each

22.0000

1

1

D2573

Saddle, Aft Out 205

**

Location

Loc Qty

Loc Code

ST423

-12

79424

0

ST433

22

83453

4

83454

6

83669

12

ST434

12

83669

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unauthorized <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

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Work Order ID: 85242

85242

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2574

Manufactured No

110

Each

22.0000

1

1

D2574

Saddle, Aft In 205

**

Location

Loc Qty

Loc Code

ST433

22

83455

4

83456

6

83671

12

83671

D2876

Manufactured No

110

Each

132.0000

2

2

D2876

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST020

132

79693

9

83323

40

83890

83

83890

D2877

Manufactured No

110

Each

102.0000

2

2

D2877

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST020

102

83324

39

83891

63

83324

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3403-1

Manufactured No

110 Each

55.0000

8

8

**

D3403-1

Bushing

Location

Loc Qty

Loc Code

ST041

15

70696

15

ST042

40

80208

7

80219

4

81529

29

81529

8

**

D3403-5

Manufactured No

110 Each

38.0000

8

8

**

D3403-5

Bushing

Location

Loc Qty

Loc Code

ST042

38

81531

38

Manufactured No

110 Each

172.0000

4

4

**

D2747

D2747

Set Screw

Location

Loc Qty

Loc Code

ST017

172

79520

5

81877

167

Manufactured No

110 Each

106.0000

2

2

**

D3533-1

D3533-1

Set Screw

Location

Loc Qty

Loc Code

ST053

106

80326

6

83892

100

83892

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Work Order ID: 85242

85242

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

567.0000

16

16

AN4C6A

Bolt

**

121657 JB



Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

563

116704

2

121656

61

21658

500

AN4C53A

Purchased

No

110

Each

22.0000

4

4

AN4C53A

Bolt

**

121183 JB



Location

Loc Qty

Loc Code

ST361

22

121183

22

AN4C52A

Purchased

No

110

Each

56.0000

4

4

AN4C52A

BOLT

**

120364 JB



Location

Loc Qty

Loc Code

ST361

56

117688

6

120364

50

AN6C12A

Purchased

No

110

Each

38.0000

8

8

AN6C12A

BOLT

**

121541 JB 12/07/03

Location

Loc Qty

Loc Code

ST341

38

121541

38

121541

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Shop Packet Print

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No

110 Each

655.0000

32

32

**

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

655

84361

655

Purchased No

110 Each

0.0000

32

32

**

AN960C416L

NAS1149C0432R

*AN960C.416I *

WASHER

D3672-9

Manufactured No

110 Each

348.0000

8

8

**

D3672-9

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

348

81763

348

Purchased No

110 Each

231.0000

8

8

**

NAS1149C0632R

NAS1149C.0632R

WASHER

Location

Loc Qty

Loc Code

ST297

231

119736

2

121060

29

121825

200

Manufactured No

110 Each

243.0000

8

8

**

D3672-11

D3672-11

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

243

77483

243

77483

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Work Order ID: 85242

85242

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,287.000

29

29

**

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1247

119546

131

121162

616

121652

500

121162

D3403-3

Manufactured

No

110

Each

29.0000

8

8

**

D3403-3

Bushing

Location

Loc Qty

Loc Code

ST042

29

81530

7

84503

22

D3405-041

Manufactured

No

110

Each

16.0000

1

1

**

D3405-041

Lug Assembly

Location

Loc Qty

Loc Code

ST478

16

62227

2

77000

2

83896

12

83370 12/07/03

Picklist Print

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

12.0000

1

1

✓

D3405-043

Lug Assembly

**

JB

SP

Location

Loc Qty

Loc Code

ST478

12

82038

1

83897

11

83897

AN4C7A

Purchased

No

110

Each

143.0000

4

4

✓

AN4C7A

Bolt

**

JB

SP

Location

Loc Qty

Loc Code

ST356

143

109147

143

109147

D3407-041

Manufactured

No

110

Each

25.0000

1

1

✓

D3407-041

Tow Ring

**

JB

SP

Location

Loc Qty

Loc Code

ST463

25

82067

6

82068

19

82068

D3417-3

Manufactured

No

110

Each

31.0000

2

2

✓

D3417-3

Washer

**

JB

SP 12/07/03

Location

Loc Qty

Loc Code

FG

9

33519

9

ST042

22

80225

22

80225

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110 Each

149.0000

1

1

**

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

142

80252

1

81876

41

83584

100

81876

AN3C37A

Purchased No

110 Each

141.0000

1

1

**

AN3C37A

BOLT

Location

Loc Qty

Loc Code

ST354

141

116874

11

117010

2

120422

3

121068

75

121585

50

121068

AN3C40A

Purchased No

110 Each

24.0000

1

1

**

AN3C40A

BOLT

Location

Loc Qty

Loc Code

ST354

24

114442

24

114442

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Work Order ID: 85242

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

85242

D412-742-013

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

138.0000

1

1

✓

AN3C41A

BOLT

**

JB

SP1

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

134

120753

24

121013

30

121313

80

121013

AN3C42A

Purchased

No

110

Each

32.0000

1

1

✓

AN3C42A

BOLT

**

JB

SP

Location

Loc Qty

Loc Code

ST354

32

106176

1

120464

6

121103

25

121103

AN3C43A

Purchased

No

110

Each

92.0000

4

4

✓

AN3C43A

BOLT

**

JB

SP

12/07/03

Location

Loc Qty

Loc Code

ST354

92

114455

2

119673

1

120465

89

120465

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Work Order ID: 85242

85242

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No

AN3C46A
BOLT

110 Each 53.0000 5 5 ✓

Location

Loc Qty

Loc Code

ST355

53

120447

53

120447

AN960C10L NAS1149C0332 Purchased No

***AN960C10L ***
R

110 Each 0.0000 26 26 ✓

122063

MS21043-3 washer Purchased No

MS21043-3
Nut

110 Each 1,557.000 13 13 ✓

12/07/03

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

14

120693

14

ST301

1471

118077

2

118614

51

118686

30

119758

20

121255

368

121708

1000

121255